

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24161-2
<b>Description:</b> Dart 13-Man Shoulder Harness Kit, 4 point (205/212/214/412)		<b>Part Number:</b>	D412-702-021
<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A1		<b>Qty:</b>	2 Kit(s)
<b>Ref:</b> D412-702 Rev.B page 11		Page 3 of 3	

Step	Location	Procedure	By	Date	Qty
38	GA	Bond D3195-7 into D3195-3 as per Dwg D3195 <b>Pick:</b> Qty A/R Description Contact Cement Batch			
39	QC5	Inspect work to Step 38			
40	GA	Assemble (2) D3197-041 as per Dwg D3197. (Note: D3197-1 is on BOM as material from Step 7) <b>Pick:</b> Qty Part Number Description Batch 4 D2690-5 Lanyard 2 D3197-1 Bar 4 D3242-1 Tag 12 AN960JD10 Washer 4 DARS-004 Pip Pin 4 MS21042L3 Nut (or -3) 4 MS27039-1-24 Screw Identify as D3197-041			
41	QC5	Inspect work to Step 40			
42	KP	<b>Pick: Packing Kit (Note: D3195-041/-043, D3196-1/-3/-4 are on BOM as material from Steps 3-6, 35-36)</b> Qty Part Number Description Batch 2 D3195-041 Bracket 2 D3195-043 Bracket 1 D3196-1 Bar 1 D3196-3 Bar 1 D3196-4 Bar 2 D3197-041 Bar 4 D3198-1 Fitting 2 D3268-1 Placard 9 D3446-041 Harness Assembly 4 D3446-043 Harness Assembly 4 AN4-5A Bolt 4 AN4-13A Bolt 8 AN4-20A Bolt 20 AN960JD416 Washer 12 MS21042L4 Nut (or -4) 8 MS24694-S152 Screw			
43	QC4	Inspect Kit 100% for Completeness on the W/O			
44	PK	Identify and pack for shipping as per PPP D412-702-021			
45	AC	Cost / part:			
46	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.09.01	New issue	KJ/JLM	



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<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A1		<b>Qty:</b>	2 Kit(s)
<b>Ref:</b> D412-702 Rev.B page 11		Page 1 of 3	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note: D412-702-021 Kit consists of (2) D3195-041; (2) D3195-043; (1) D3196-1; (1) D3196-3; (1) D3196-4; (2) D3197-041.</b>	R	05/09/07	2
2	DC	Photocopy bluefile and create labels per PPP D412-702-021 CHG001			
3	MV	Cut (2) blanks per (1) D412-702-021 Kit Cut blanks: (0.75" x 2.00") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B0.750x02.000) Identify for D3195-1 Batch: _____			
4	MV	Cut (2) blanks per (1) D412-702-021 Kit Cut blanks: (1.50" x 1.25") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.500x01.250) Identify for D3195-3 Batch: _____			
5	MV	Cut blank: (0.75" x 1.50") x 26.200" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify for D3196-1 Batch: _____			
6	MV	Cut (2) blanks per (1) D412-702-021 Kit Cut blanks: (0.75" x 1.50") x 34.750" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify (1) for D3196-3 Identify (1) for D3196-4 Batch: _____			
7	MV	Cut (2) blanks per (1) D412-702-021 Kit Cut blanks: 29.125" long Round Bar Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD (M7075T73R1.000) Identify for D3197-1 Batch: _____			
8	MV	Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr and Tumble			
11	QC8	Second check			
12	MV	Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3			
13	QC2	Inspect parts as they come off the CNC machine			
14	MV	Deburr and Tumble			
15	QC8	Second check			
16	MV	Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1			
17	QC2	Inspect parts as they come off the CNC machine			

RELEASED  
12/05/07